

Amendments to the Claims:

This listing of claims replaces all prior versions and listings of claims in the application:

Listing of Claims:

1.-34. (Cancelled).

35. (New) A needle (1) for penetrating a membrane (2), having a pointed end (3) provided with a penetrating tip (4) and with an opening (6) for letting a liquid in and/or out in a main direction (7) which is substantially parallel to the longitudinal extension of the needle, wherein the penetrating tip (4) is designed with a substantially point-shaped edge (8) to initially prick a membrane (2) when the membrane is penetrated and that the outer edges (19) present on the pointed end (3) in the area between the point-shaped edge (8) and a position (25) beyond the opening (6) are rounded so that after the initial penetration the pointed end (3) will push the membrane material away rather than cutting the membrane material.

36. (New) A needle according to claim 35, wherein the inner edge (21) of the opening (6) is rounded.

37. (New) A needle according to claim 35, wherein the penetrating tip (4) is designed with a cross section (26) having a symmetry causing at least three substantially equally sized forces (F) in different directions which are radial to the longitudinal centre line (5) of the needle and which forces counteract each other so that the needle (1) will tend not to deviate from the initial penetration direction when the needle (1) penetrates a membrane (2).

38. (New) A needle according to claim 37, wherein the cross section is substantially triangular with rounded edges.
39. (New) A needle according to claim 37, wherein the cross section is substantially circular.
40. (New) A needle according to any of claims 35, wherein the point-shaped edge (8) of the penetrating tip (4) is arranged to lie substantially on the longitudinal centre line (5) of the needle (1).
41. (New) A needle according to any of claims 35, wherein the pointed end (3) has a shape substantially corresponding to a part of an imaginary cone, the tip (9) of which coincides with the substantially point-shaped edge (8).
42. (New) A needle according to any of claims 35, wherein at least a major part of the opening (6) is arranged on one and the same half of the cross section of the needle (1).
43. (New) A needle according to any of claims 35, wherein the pointed end (3) is provided with a basic shape in accordance with a lancet bevel cut.
44. (New) A needle according to any of claims 35, wherein the pointed end (3) is provided with a basic shape in accordance with a back bevel cut.
45. (New) A needle according to claim 44, wherein the back bevel cut has a tip angle ( $\alpha$ ) in the interval  $20^{\circ}$  to  $50^{\circ}$ .
46. (New) A needle according to claim 44, wherein the back bevel cut has a tip angle ( $\alpha$ ) in the interval  $50^{\circ}$  to  $100^{\circ}$ .

47. (New) A needle according to claim 44, wherein the back bevel cut has a tip angle ( $\alpha$ ) in the interval  $30^\circ$  to  $80^\circ$ .

48. (New) A needle according to claim 47, wherein the tip angle ( $\alpha$ ) is approximately  $75^\circ$ .

49. (New) A needle according to any of claims 44, wherein the back bevel cut has a second grind angle ( $\beta$ ) in the interval  $50^\circ$  to  $140^\circ$ .

50. (New) A needle according to claim 49, wherein the second grind angle ( $\beta$ ) is approximately  $100^\circ$ .

51. (New) A needle according to any of claims 35, wherein the needle is provided with a tip angle ( $\alpha$ ) in the interval  $20^\circ$  to  $100^\circ$ .

52. (New) A needle according to claim 51, wherein the tip angle ( $\alpha$ ) is in the interval  $30^\circ$  to  $80^\circ$ .

53. (New) A needle according to any of claims 35, wherein the needle is provided with a rear angle ( $\beta$ ) in the interval  $50^\circ$  to  $140^\circ$ .

54. (New) A needle according to claim 53, wherein the rear angle ( $\beta$ ) is approximately  $100^\circ$ .

55. (New) A needle for penetrating a membrane (2), said needle (1) having a pointed end (3) provided with a penetrating tip (4) and with an opening (6) for letting a liquid in and/or out in a main direction (7) which is substantially parallel to the longitudinal extension of the needle (1), wherein the point-shaped edge (8) of the penetrating tip (4) is arranged to lie substantially on the longitudinal centre line (5) of the needle (1), and the penetrating tip (4) is designed with a cross

section (26) having a symmetry causing at least three substantially equally sized forces (F) in different directions which are radial to the longitudinal centre line (5) of the needle and which forces counteract each other so that the needle (1) will tend not to deviate from the initial penetration direction when the needle (1) penetrates a membrane (2).

56. (New) A needle according to claim 55, wherein the cross section is substantially triangular with rounded corners.

57. (New) A needle according to claim 55, wherein the cross section is substantially circular.

58. (New) A method for manufacturing a needle (1) for penetrating a membrane (2), comprising: cutting a tubular blank (15) obliquely for obtaining a pointed end (3) provided with a penetrating tip (4) and with a opening (6) for letting a liquid in and/or out in a main direction (7) which is substantially parallel to the longitudinal extension of the needle (1), characterized by providing the penetrating tip (4) with a substantially point-shaped edge (8), and rounding all outer edges (19) present on the pointed end (3) in the area between the point-shaped edge (8) and a position (25) beyond the opening (6).

59. (New) A method according to claim 58, characterized by rounding the inner edge (21) of the opening (6).

60. (New) A method according to claim 58 or 59, characterized by shaping the penetrating tip (4) with a cross section (26) having a symmetry causing at least three substantially equally sized forces (F) in different directions which are radial to the longitudinal centre line (5) of the needle (1) and which forces counteract each other so that the needle (1) will tend not to deviate from the initial penetration direction when the needle (1) penetrates a membrane (2).

61. (New) A method according to claim 58 or 59, characterized by arranging the point-shaped edge (8) of the penetrating tip (4) to lie substantially on the longitudinal centre line (5) of the needle (1).

62. (New) A method according to any of claims 58 or 59, characterized by shaping the pointed end (3) as a part of an imaginary cone, the tip (9) of which coincides with the substantially point-shaped edge (8).

63. (New) A method according to any of claims 58 or 59, characterized by shaping the pointed end (3) so that at least a major part of the opening (6) will be located on one and the same half of the cross section of the needle (1).

64. (New) A method according to any of claims 58 or 59, characterized by grinding the penetrating tip (4) in accordance with a lancet bevel cut before rounding the outer edges of the pointed end (3).

65. (New) A method according to any of claims 58 or 59, characterized by grinding the penetrating tip (4) in accordance with a back bevel cut before rounding the outer edges of the pointed end (3).

66. (New) A method according to any of claims 58 or 59, characterized by shaping the penetrating tip (4) by a non-cutting process.

67. (New) A method according to any of claims 58 or 59, characterized by rounding the outer edges (19) by blasting and/or electrochemical polishing.

68. (New) A method according to claim 59, characterized by rounding the inner edge (21) of the opening (6) by blasting and/or electrochemical polishing.

69. (New) A needle according to claim 37, wherein the point-shaped edge (8) of the penetrating tip (4) is arranged to lie substantially on the longitudinal centre line (5) of the needle (1).

70. (New) A needle according to claim 37, wherein the pointed end (3) has a shape substantially corresponding to a part of an imaginary cone, the tip (9) of which coincides with the substantially point-shaped edge (8).

71. (New) A needle according to claim 40, wherein the pointed end (3) has a shape substantially corresponding to a part of an imaginary cone, the tip (9) of which coincides with the substantially point-shaped edge (8).

72. (New) A needle according to claim 37, wherein at least a major part of the opening (6) is arranged on one and the same half of the cross section of the needle (1).

73. (New) A needle according to claim 37, wherein the pointed end (3) is provided with a basic shape in accordance with a lancet bevel cut.

74. (New) A needle according to claim 37, wherein the pointed end (3) is provided with a basic shape in accordance with a back bevel cut.

75. (New) A needle according to claim 48, wherein the back bevel cut has a second grind angle ( $\beta$ ) in the interval  $50^\circ$  to  $140^\circ$ .

76. (New) A needle according to claim 37, wherein the needle is provided with a tip angle ( $\alpha$ ) in the interval  $20^\circ$  to  $100^\circ$ .

77. (New) A needle according to claim 37, wherein the needle is provided with a rear angle ( $\beta$ ) in the interval 50° to 140°.

78. (New) A method according to claim 60, characterized by arranging the point-shaped edge (8) of the penetrating tip (4) to lie substantially on the longitudinal centre line (5) of the needle (1).

79. (New) A method according to claim 60, characterized by shaping the pointed end (3) as a part of an imaginary cone, the tip (9) of which coincides with the substantially point-shaped edge (8).

80. (New) A method according to claim 60, characterized by shaping the pointed end (3) so that at least a major part of the opening (6) will be located on one and the same half of the cross section of the needle (1).

81. (New) A method according to claim 60, characterized by grinding the penetrating tip (4) in accordance with a lancet bevel cut before rounding the outer edges of the pointed end (3).

82. (New) A method according to claim 60, characterized by grinding the penetrating tip (4) in accordance with a back bevel cut before rounding the outer edges of the pointed end (3).

83. (New) A method according to claim 60, characterized by shaping the penetrating tip (4) by a non-cutting process.

84. (New) A method according to claim 83, wherein said non-cutting process comprises forging or hammering.

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Serial No. : To Be Assigned  
Filed : July 20, 2005  
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Attorney's Docket No.: 19497-002US1 / P16657US01

85. (New) A method according to claim 60, characterized by rounding the outer edges (19)  
by blasting and/or electrochemical polishing.